

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018939**Date Inspected:** 04-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #10

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 3D located on Bike path BK 007- BKPL, Edge plate build up as per WRR no. B-WR-16922. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -3G (3F) -Repair.

Repair welding of Weld joint # 3C located on Bike path BK 007- BKPL, Edge plate build up as per WRR no. B-WR-16922. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -3G (3F) -Repair.

Repair welding of Weld joint # 7A located on Bike path BK 007- BKX7EA, Edge plate build up as per WRR no. B-WR-16922. Welder is identified as 053879. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -3G (3F) -Repair.

Weld joint # 002, 007 located on Bike path BK 004A6 -030. Welder is identified as 057258, 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2312 –TC –P4.

Weld joint # 001, 130 located on Bike path BK 004A8 -030. Welder is identified as 0500363, 05249930 ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2313 –TC –P4.

Tower

Flux Cored Arc Welding (FCAW)

Weld joint # 11, 12 located on Façade plate Manhole cover SD1 –SFSA4 -6A/B. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T -2132.

Weld joint # 13, 14 located on Façade plate Manhole cover SD1 –SFSA4 -6A/B. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T -2333 –B –P3 -F.

Visual Inspection Testing (VT):

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07615

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Bike path Hold point 3. The weld designations reviewed are as follows:

BK 004A2 -030

Bay #11

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Weld joint # 38 located on East Tower, Lift4, Skin E, Ladder support plate ESD1-FASA4 -2 A/E. Welder is identified as 068091. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P - 2112.

Weld joint # 39 located on East Tower, Lift4, CD Corner end cap of diagonal plate ESTL4 -2 D/L. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P - 2112.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07621

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as OBG Bike path components. The weld designations reviewed are as follows:

BK004A3 -019 – Jt. nos. -002, 004, 010

BK004A5 -019 – Jt. nos. -002, 008

BK004A6 -019 – Jt. nos. -072, 073

BK004A8 -019 – Jt. nos. -072, 073

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer